

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009946**Date Inspected:** 03-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Trail Assembly Yard

This QA Inspector performed MT of approximately 15% of repair areas previously tested and accepted by Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 5AE panel points 30~32.5 and 1AW panel point 8.5 diaphragm to floor beam flange. The weld designations reviewed are as follows:

Repair areas at Panel Point 30~32.5

1. FB003-000-005(P.P. 30)
2. FB016-000-003/004, FB003-000-005 (P.P. 31)
3. DP631A-000-014/016 (P.P. 32.5)
4. EP50A-000-007(P.P. 32.5)
5. SP425A-000-012, 017(P.P. 32.5)

Repair areas at Panel Point 8.5

1. FB89-000-005

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5CE

FCAW welding on t stiffeners to bottom plate weld joints 033, 034 located at BP166-001.

Welder is identified as Mr. LI Guimin (220069). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

6AE

FCAW welding on t stiffeners to bottom plate weld joints 033, 034 located at BP166-001.

Welder is identified as Mr. LI Guimin (220069). ZPMC QC is identified as Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

NDT Observation

QA Inspector observed ABF's personnel performing MT inspection on repair areas. Locations and description of work are as followed:

1AAW+1AW

Excavation repair area on OBW1A-005 side plate (external) weld joint (cross beam) side of segment 1W.

Y locations of MT Indications observed are as followed:

1. Y Location 65mm, ABF observed an 8mm transverse crack on center of weld splice.

This QA Inspector observed ZPMC Ultra Sonic (UT) Technician performing UT on various locations in the trial assembly yard. Locations are as followed:

1. UT inspection was in progress on longitudinal diaphragm to panel point 35 web weld joint.

This QA Inspector observed ABF Ultra Sonic (UT) Technician performing UT on various locations in the trial assembly yard. Locations are as followed:

1. UT inspection was performed on repair area on edge plate (cross beam side) weld joint OBW1-003.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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